

Date: Monday, 2/5/2007 3:46:29 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 30640		
Estimate Number	: 10713		
P.O. Number	: N/A	Part Number	: D3213041
This Issue	: 2/5/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3213 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25254	Drawing Revision	: A
		Material	: N/A
Written By	:	Due Date	: 2/15/2007
Checked & Approved By	:	Qty:	4 Um: Each
Comment	: Est Rev: A New Issue 05-11-17 17:27		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31613	Hinge 15.0"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2	D3161-3	Hinge	B19672 X7
			B23189X1

PTO

2.0	D32131	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1	D3213-1	Door	B30656 x4
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Can not scan

3.0	D32133	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1	D3213-3	Door	B30657 B30657 x4
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Can Not Scan

4.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Assembly Kit

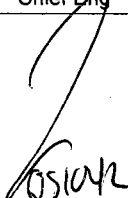
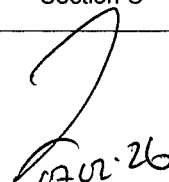

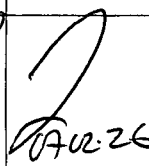
Qty Part Number Description Batch

24	MS20470AD4-4	Rivet	M18729 X96
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mulo1/02/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/20	1	Found one D3161-3 to short (14.800)" of Batch B 23189 <u>Scrapone Holes don't match</u>		Scrap <del>two</del> D 3161-3 replace by new one B23189	nil 07/02/20	 07.02.20		 07.02.20
				<del>a new jig for door assy will be appreciate!</del> nil	nil 07/02/20			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30640

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

x4

(P10)

ml 07/02/21

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/02 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

LF/ gm

07-03-07 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 07-03-09 4

9.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2137 Decal B24358

FF 07-03-09 4

10.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2419 Handle B28202

FF 07-03-09 4

11.0

D2462

Neoprene Seal



Comment: Qty.: 2.4000 f(s)/Unit Total : 9.6000 f(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2462 Seal B29456

FF 07-03-09 4

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/02

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-02-26	S.O	4x 3161-3 scrap. The original drill jig to do the holes that get riveted on to the D3210-1, was not very good. Holes were oval oversized, causing major hole mis-alignment between the two parts. → ①	AS1042	Scrap. Replace the top hinge. Use new drill jig D78470 to do the holes as per Dwg.		07/07/02	AS1042	07-02-26
				Take out 28 rivets Scrap 4 hinges 1/2" replace them by new one D3161-3 B30652 ✓ MS 20470 AD 4-4 M103044 ✓	mul 07/02/02			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30640

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D27281

Dart Logo label small



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-1 Decal B24215

FF 07-03-09

4

13.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN960JD6 Washer M6085

FF 07-03-09

4

14.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet

M18615

FF 07-03-09

4

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3213

FF 07-03-09

4

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/09 (4)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Boyle 03/09*

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/12

(4)

Job Completion



*u 07/03/12*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

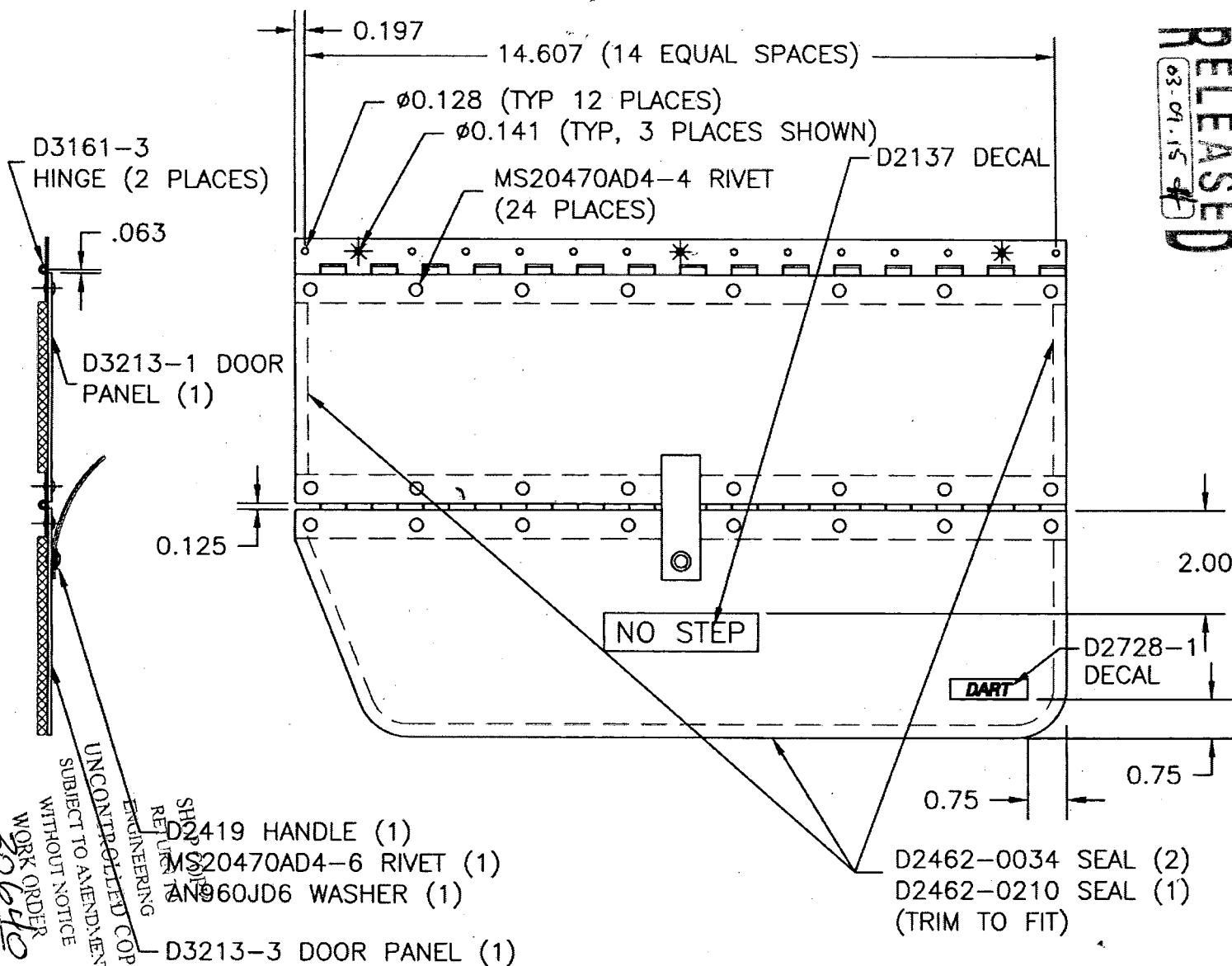
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	✓	APPROVED	✓	HAWKESBURY, ONTARIO, CANADA
DATE	03.09.03	TITLE	D3213	REV. A
A	03.09.03	DOOR ASSEMBLY	NEW ISSUE	1 OF 2
				SCALE 1:3

RELEASED  
03.09.15



### D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

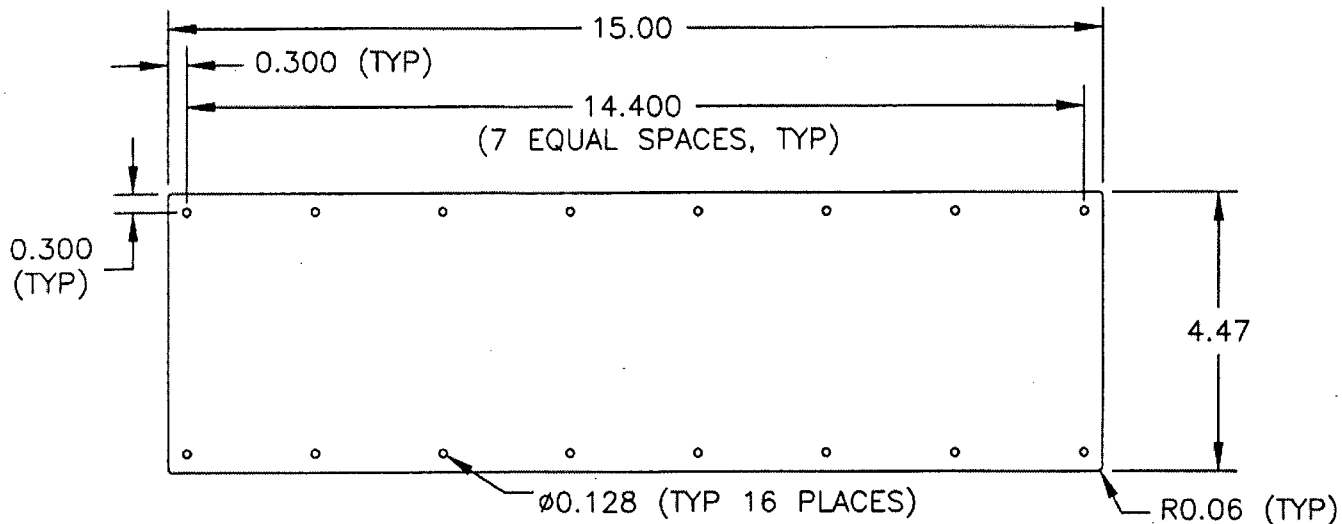
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

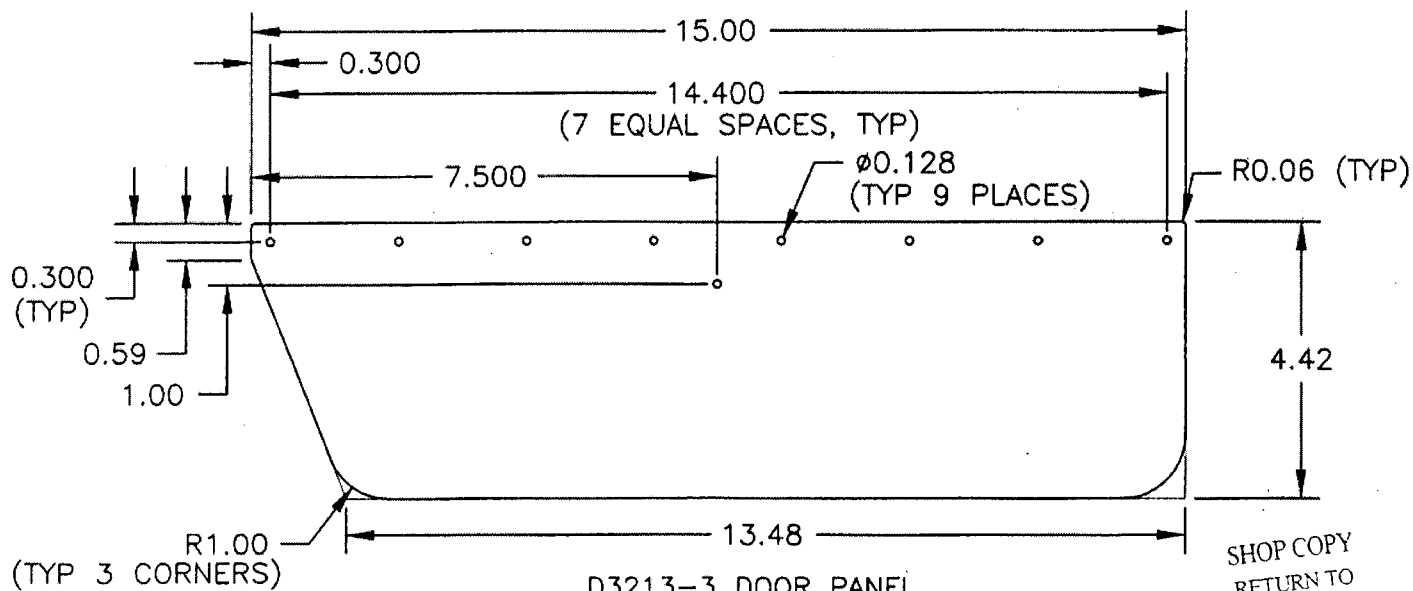
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
03.09.15

SHOP COPY  
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WORK ORDER  
NO. 30640

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